

Work Order ID 70950

Monday, June 20, 2011 9:21:04 AM



Page 1

Item ID:	D3619-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Grommet					
Start Date:	6/20/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	6/22/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/06/20</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3619	Rev A								

100		0.00							
	PURCHASING								<u>CL 11/06/20 10</u>
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>1435</u> <input type="checkbox"/> Purchase Part Number: 9610K18 <input type="checkbox"/> Supplier: MC MASTER CARR <input type="checkbox"/> Certificate of conformity is required								

110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								<u>CL 11/06/23 10</u>
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								

120		0.00							
	QC6- Inspect dimensions to drawing								<u>8ul04173</u>
QC	Memo	0.00							<u>(10)</u>
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3619-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Grommet

Start Date: 6/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	****Remove supplier paperwork from box.***** <input type="checkbox"/> Identify and Stock <input type="checkbox"/> Location: <u>5T70</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

JB (10) 11/06/24

11/06/27

MF
11-06-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70950



Parent Item: D3619-2



Parent Item Name: Grommet



Start Date: 6/20/2011

Required Date: 6/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-04-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
9610K18  GROMMET		Purchased	No			110	Each	0.0000	1 	10		06/11/2011	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

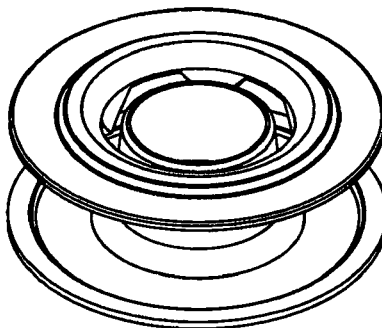
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3619	REV. A SHEET 1 OF 1
DATE 07.03.26		TITLE GROMMET	SCALE NTS
REV A	DATE 07.03.26	DESCRIPTION NEW ISSUE	

SPECIFICATION CONTROL DRAWING



RELEASED
07 04 02 *[Signature]*

D3619-X GROMMET,
WHERE X REPRESENTS THE GROMMET TRADE SIZE

DART P/N	TRADE SIZE	DESCRIPTION	HOLE SIZE	MAX. MTL THICKNESS	MCMaster CARR P/N
D3619-0	0	BRASS GROMMET W/ TEETH	1/4	0.110	9610K16
D3619-1	1	BRASS GROMMET W/ TEETH	9/32	0.120	9610K17
D3619-2 <i>+</i>	2	BRASS GROMMET W/ TEETH	3/8	0.150	9610K18
D3619-3	3	BRASS GROMMET W/ TEETH	7/16	0.230	9610K19
D3619-4	4	BRASS GROMMET W/ TEETH	1/2	0.300	9610K21

NOTES:

1) PURCHASE INFO: MCMaster-CARR P/N'S INCLUDE THE FOLLOWING:

48 GROMMETS FOR SIZE 0 & 1,
24 GROMMETS FOR SIZE 2, 3 & 4,
D3619-XT1 HOLE PUNCH,
D3619-XT2 STRIKER BLOCK,
D3619-XT3 PUNCH AND
D3619-XT4 DIE

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

CH 11/06/20
W10: 70950

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1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO14315

McMaster-Carr Number
8363875-01

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06/20/2011

Line	Description	Ordered	Shipped
1	9610K18 Military Specification Grommet Kit, with Teeth Washer, Trade Size 2, 3/8" ID, 24 Grommets	10 Each	10
	Unit Price: \$13.31		
	Extended Price: \$133.10		
2	6605K56 Hook and Loop Cable Tie, Black Flame-Retardant Wrap Around, 24" L, 3/4" Width, Packs of 5	5 Packs	5
	Unit Price: \$13.89		
	Extended Price: \$69.45		
3	5969A11 Hard Nylon Dead Blow Hammer, 1-7/16 lb, 1-9/16" Face Diameter, 12-1/4" L Overall	1 Each	1
	Unit Price: \$25.06		
	Extended Price: \$25.06		

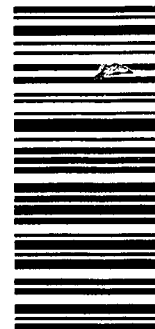
8/11/06 4/23
CL11/06/23

1 - 312 - 04	01 - 02	K18	10 EA	1
12 lbs				
3 - 125				2
1 - 510				3

A83

Dart Aerospace Ltd

EXP
HZ-M



21 lbs
5 lines

Lg

38x12x12

SS-R-0707

FW1BSP21
06/20/2011
13:00/13:47
076
Cycle 44

1140060177558

